

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014045**Date Inspected:** 15-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:			

Summary of Items Observed:

This inspector performed conventional ultrasonic testing, UT, on OBE8C-003, Section 8BE-8CE, Bottom Plate. This inspection was in conjunction with ABF UT personnel, and to verify indications found during the ABF inspection. No additional recordable indication was noted at the time of inspection.

This inspector performed magnetic particle testing, MT, in accordance with NWIT 005714 on tower shear plate A27. This part is identified as ED1-A27-B/E. The weld numbers tested were 21, 23, 28, and 29. No recordable indication was observed at the time of testing.

This inspector performed a production monitoring test, PMT, on deck panel on a 500mm, 3 rib specimen to qualify the welding machine and welders to weld deck panels DP3118-001, and DP3122-001. The welding procedure was identified as WPS-B-T-2342-U1(U-rib)-5. The preheat for the welding operations was noted to be 60C or above at the time of welding. This inspection was in conjunction with ZPMC CWI Chen Shigang, and ABF QC Cao Haizhou. The welders noted on Gantry welder 1 in bay 9 are as follows:

203805
059378
059418
059421
059416
201788

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15 macro samples were marked for destructive testing. Samples were cut and polished by ZPMC personnel but were not given to this inspector for verification after acceptance by ZPMC and ABF QC personnel due to shift change. Results from all macro etch samples were reported as acceptable by QA inspector Stefan Holmes.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
